

Date: Friday, 10/13/2006 9:27:54 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 28963		
Estimate Number	: 12428		
P.O. Number	: <u>N/A</u>	Part Number	: D35061
This Issue	: 10/13/2006 S.O. No. : <u>N/A</u>	Drawing Number	: D3506 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 27714	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 10/30/2006 Qty: 20 Um: Each
Checked & Approved By	: <u>[Signature]</u> 061013		
Comment	: Est Rev: A New Issue 06-05-31 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S100	6061-T6 .100 Sheet
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Comment: Qty.: 0.0082 sf(s)/Unit Total: 0.1638 sf(s)

6061-T6 .100 Sheet

(M6061T6S0100)

Batch: M102201ml 061109

(20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3506

Dwg Rev: AProg Rev: Aml 061109

(20)

2-Deburr if necessary

SAD 06:10:14

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:10:14

20

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA640 and Dwg D3506

J.F. 07/03/01

(20)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/03/01

(20)

3.1

QC 8

Second check

1/12/06/11/10

(20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3506-1 PAR #: \_\_\_\_\_ Fault Category: Prod/Engineering NCR: (Yes) No DQA: (S) Date: 07/03/06  
 could not find QA: N/C Closed: (S) Date: 07.03.09

NCR: <u>28963</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/02	2.0 3.0	Parts do not have 45° chamfer was not in the Dxf when the parts were cut on the water jet, and the chamfer wasn't picked up on the F.A.I.	<u>(Signature)</u>	Qty 20 ScrAP. 3 Replace	<u>(Signature)</u> 06/11/09	<u>(Signature)</u>	<u>(Signature)</u>	<u>(Signature)</u>

NOTE: Date & initial all entries

Date: Friday, 10/13/2006 9:27:55 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28963

Part Number: D35061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07/03/05

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'sink as per Dwg D3506(On Flat side)

SAO

07/03/05

(20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/05

(20)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H

07/03/05

(20x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/05 (20x) U

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/03/05 (20x)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/06


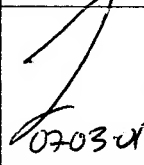
(20)

Job Completion



11 07-03-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
070301	5.0	Add A thickness <del>to</del> dimension to the drawing for how thick the material has to be machined down to in the middle of the Radius. .060" thick at the center.				 070301	 070301	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

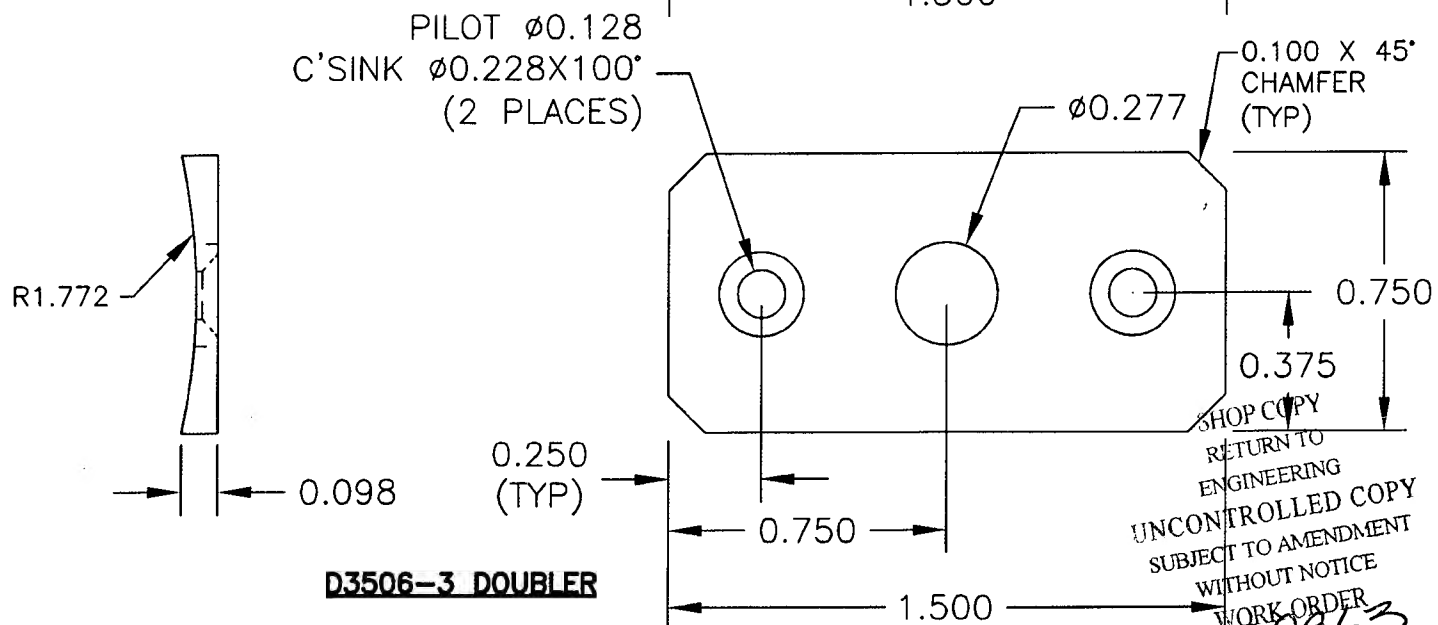
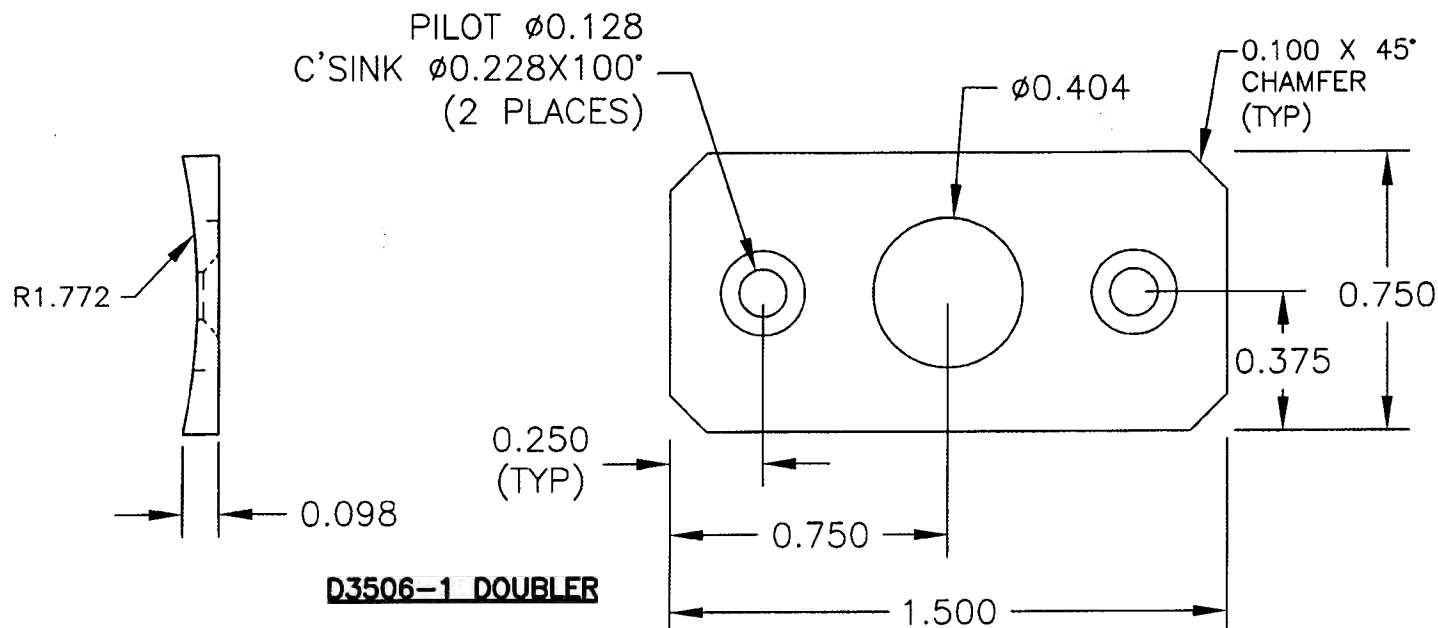
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)  
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**RELEASED**  
06.10.03 PH  
PER EEN #861

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> Q8963
<b>Description:</b> Doubler	<b>Part Number:</b> D3506-1
<b>Inspection Dwg:</b> D3506-1 Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	<i>MM. MM</i>
Date:	<i>B 11 09</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	